

CLAIM:

1. A method of surface treating a cookware article formed of aluminium or aluminium alloy, comprising  
5 the steps of:
  - a) applying a first coating of porcelain enamel to the exterior of the article;
  - b) subjecting the interior of the article to hard-anodizing; and
  - c) applying a second coating of porcelain enamel over the first coating.
- 10 2. A method according to claim 1 wherein the porcelain enamel is applied as a porcelain slip which is cured at an elevated temperature.
- 15 3. A method according to claim 2 wherein the second porcelain enamel coating is subjected to curing at a temperature which is sufficient to at least partially remelt the surface of the first porcelain enamel coating.
- 20 4. A method according to claim 1 wherein the first porcelain enamel coating is applied as a layer of thickness in the range 25 to 35 microns.
5. A method according to claim 1 wherein the second porcelain enamel coating is applied as a layer of thickness in the range 30 to 35 microns.
- 25 6. A method according to claim 1 wherein the second

porcelain enamel coating is subjected to rapid drying using infra-red heating means to dry the enamel surface, followed by silkscreen printing of a pattern onto the dried surface.

- 5        7. A method according to claim 1 wherein the first porcelain enamel is heated to curing at a temperature in the region of 540 to 555°C.
8. A method according to claim 7 wherein said curing is carried out for 1 to 1.5 minutes.
- 10      9. A method according to claim 1 wherein at step b) the interior of the article is subjected to anodizing for less than 20 minutes.
10. A method according to claim 1 wherein the hard-anodized interior of the article is coated with a non-stick coating.
- 15      11. A method of forming an article of cookware of aluminium or aluminium alloy, comprising the steps of:
- i) providing a disc-like blank of flat metal;
- ii) forming the article by stamping into the desired shape;
- iii) applying a first coating of porcelain slip to the exterior of the article of thickness in the range 25 to 35 microns and curing at an elevated temperature to produce a hard enamel;
- 20      iv) subjecting the interior surface to hard-

- anodizing;
- v) applying a second coating of porcelain slip of thickness in the range 30 to 35 microns and curing to produce a hard enamel; and
- 5 vi) applying a non-stick coating to the hard-anodized interior of the article.
12. An article of cookware when formed according to the method of claim 1.
13. An article of cookware when formed according to the method of claim 11.
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14. An article of cookware of aluminium or aluminium alloy having an exterior coating of porcelain enamel, and an interior hard-anodized surface covered in a non-stick coating.
15. An article of cookware according to claim 14 wherein the total thickness of the porcelain enamel coating is in the range 60 to 70 microns.